

Friday, October 24, 2014 11:11:01 AM

Page 1

9-89

W/11/11

14/11/11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Quality Control

DAS
44 14/12/02
~~9-82~~

DAS
44 14/12/02
~~9-89~~

DAS
08
9-89

D. 14/12/02

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WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order update only ☐

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KURU d III 18/02/02

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Work Order ID 125899***125899***

Page 5

Item ID: D3488-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Blade Fitting RH

Stop ***NS2***

Start Date: 10/27/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/14/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ 15-01-12

DQA: _____ Date: _____



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Picklist Print

Friday, October 24, 2014 11:11:05 AM

Page 1

Work Order ID: 125899

125899

Parent Item: D3488-042

D3488-042

Parent Item Name: Blade Fitting RH

Start Date: 10/27/14

Required Date: 11/14/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225	AELS8-1032-225	Purchased		No			Each	226.0000		48			
---------------	----------------	-----------	--	----	--	--	------	----------	--	----	--	--	--

AI S7-1032-225
Insert

X ALS4-1032-225

1131067

**

(x48) 15/01/12

Location

Loc Qty

Loc Code

FG

80

118520

80

FP001

81

m128649

81

ST280

65

m128179

65

D6103-003

Manufactured No

Each

32.0000

12

D6103-003

Round Billet, Aluminum

**

14/11/11

DAS
40
9-89

Location

Loc Qty

Loc Code

MAT043

32

113646

12

122543

20

125918

12

DQA: _____ Date: _____

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DART AEROSPACE LTD	Work Order:	125899
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

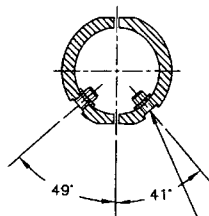
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.150	✓		MIC	PAD-07
Ø2.780	+/-0.005	2.780	✓		"	"
Ø3.125	+/-0.010	3.125	✓		VERN	PAD-12
Ø3.346	+/-0.010	3.345	✓		"	"
0.125 x 45°	+/-0.010 x +/-0.1°	.125	✓		"	"
8.000	+0.030/-0.000	8.012	✓		H-G	31006
9.250	+/-0.010	9.249	✓		"	"
0.188	+/-0.010	.188	✓		"	"
R0.032	+/-0.010	.032	✓		RAD G	
R0.062	+/-0.010	.063	✓		"	
Ø0.297	+0.005/-0.001	.299	✓		PING	
Ø0.430	+/-0.010	.433	✓		"	
0.100	+/-0.010	.100	✓		VERN	PAD-12
0.125	+/-0.010	.130	✓		"	"
2.620	+/-0.010	2.620	✓		"	"
3.500	+/-0.010	3.499	✓		"	"
1.005	+/-0.010	1.005	✓		"	"
Ø0.484	+0.005/-0.001	.485	✓		"	"
1.180	+/-0.010	1.180	✓		"	"
3.150	+/-0.010	3.150	✓		"	"
3.070	+/-0.010	3.070	✓		"	"
R0.063	+/-0.010	.063	✓		RAD G	"

DART AEROSPACE LTD		Work Order:	
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.510	✓		Vern	Fk-04
0.750	+/-0.010	.750	✓		"	"
1.500	+/-0.010	1.500	✓		"	"
11.18	+/-0.030	11.178	✓		Height gauge	3100Z
R0.062	+/-0.010	.062	✓		R-A.	
0.125	+/-0.010	.121	✓		Vern	Fk-04
0.590	+/-0.010	.591	✓		Height gauge	3100Z
0.793	+/-0.010	.800	✓		Vern	Fk-04
1.351	+/-0.010	1.348	✓		Height gauge	3100Z
1.317	+/-0.010	1.319	✓		Vern	Fk-04
1.802	+/-0.010	1.810	✓		Height gauge	3100Z

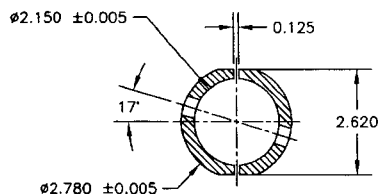
Measured by:	DAS 40 9-89	DAS 44 9-89	Audited by: D.A.	DAS 08 9-89	Prototype Approval:	N/A
	Date: 14/11/11	14/12/02		Date: 14/12/04		Date:

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



SECTION A-A

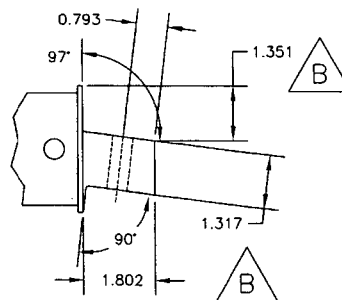
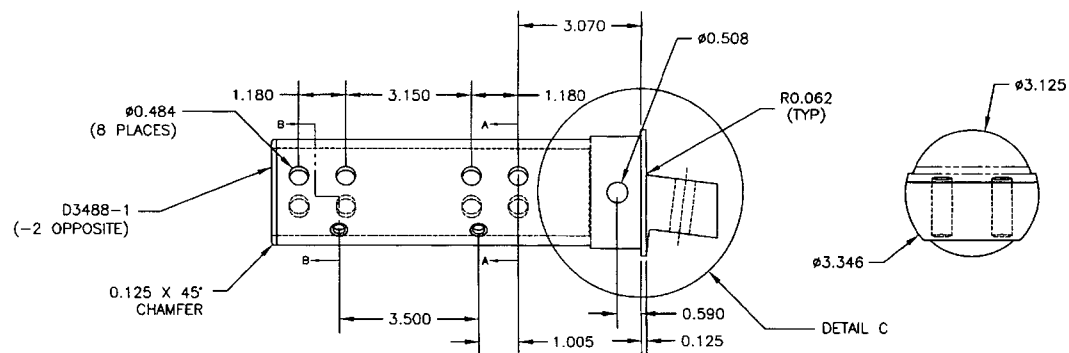
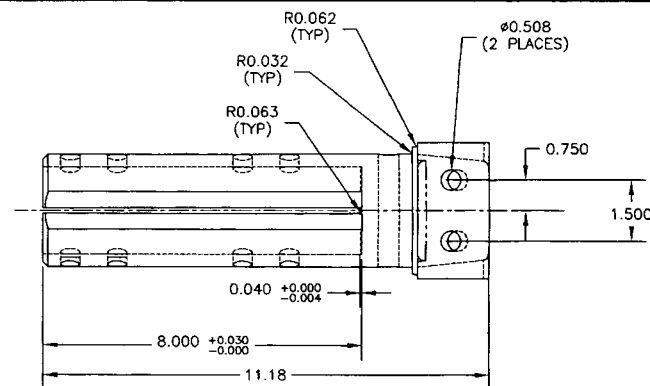
D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Handwritten: 14-10-24
1258991



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
PER DS
ECN #739

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		SCALE
		1:3

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DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DRAWING NO. D3488

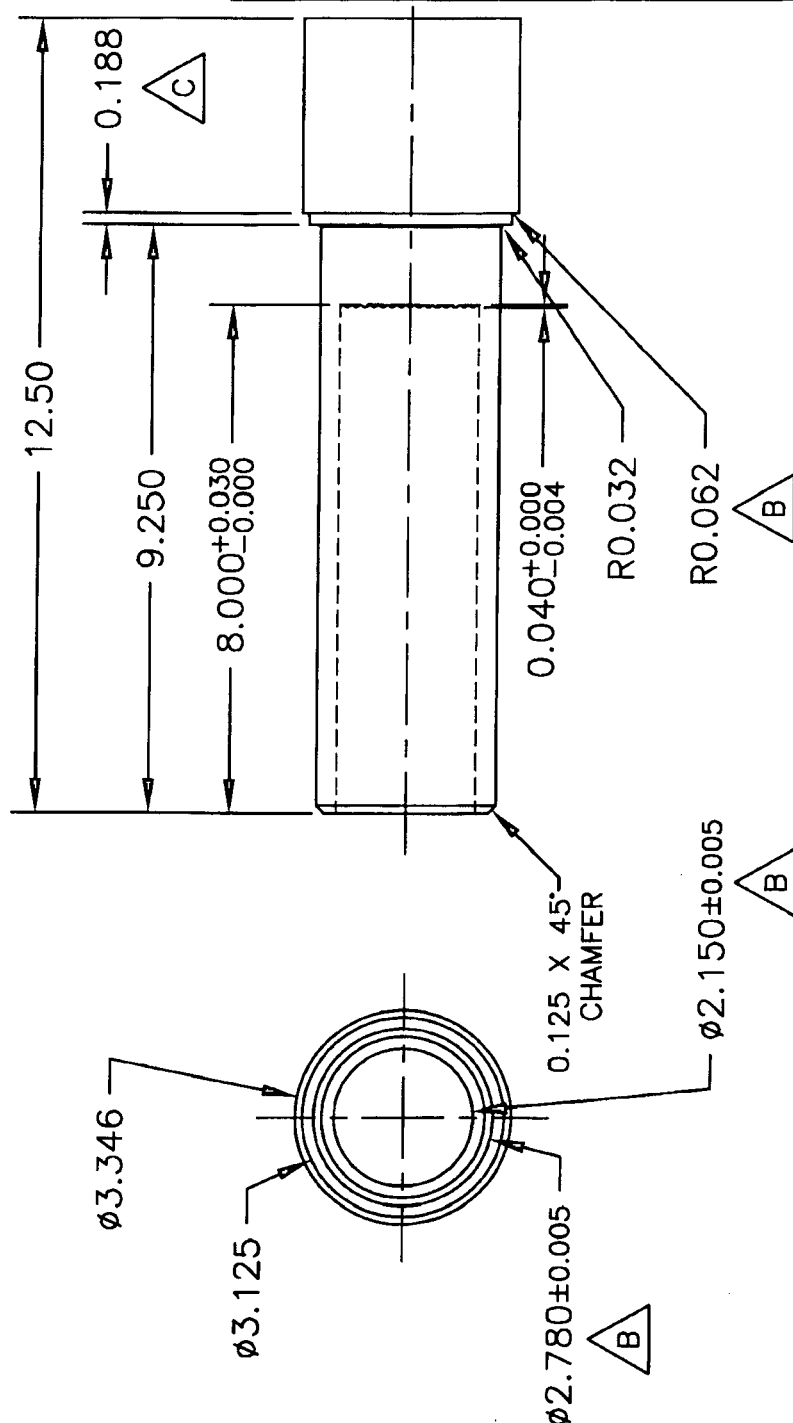
REV. B

SHEET 1 OF 1



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 101	REV. D SHEET 1 OF 1
DATE 06.05.09		TITLE D3488-1/-2 TURNING DETAIL	SCALE 1:3
A	05.12.21	NEW ISSUE	
B	06.03.02	ADD TOLERANCES AND RADIUS	
C	06.04.17	0.188 WAS 0.125	
D	06.05.09	REMOVE DIAMETER FOR CHAMFER	

06-05-09 [Signature]



- DSK 101
- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
 - 2) FINISH: NONE
 - 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#125809
141024

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